

5 insert molding a skin/flesh member on said skeleton member using a skin/flesh  
B<sup>3</sup> 6 forming material of a soft synthetic resin whereby the rigid synthetic resin and the soft synthetic  
7 resin are compatibly welded together.

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1 21. (Amended) A method for manufacturing an elastic doll as defined in claim 18  
2 wherein the elastic doll includes a trunk, arms and legs in which said skeleton member is  
3 embedded;

4 said step of insert molding said second cores includes forming fixing shafts which  
5 extend from said second cores to a surface of the doll; and

B<sup>4</sup> 6 said step of insert molding said skin/flesh member includes arranging said  
7 skeleton member in a mold for molding the skin/flesh member, fixing said fixing shafts on  
8 mating surfaces of said mold to stabilize said skeleton member and injecting the soft synthetic  
9 resin into said mold,

10 further comprising the steps of removing portions of said fixing shafts projected  
11 from the surface of the doll after molding and treating marks left on the surface of the doll due to  
12 removal of the projected portions of said fixing shafts.

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1 27. (Amended) A method for manufacturing an elastic doll which includes a trunk,  
2 arms and legs in which a skeleton member is embedded, comprising the steps of:

B<sup>5</sup> 3 providing cores made of rigid synthetic resin to constitute said skeleton member  
4 wherein fixing shafts are formed to extend from said cores to a surface of the doll;

5 arranging said skeleton member in a mold and fixing said fixing shafts on mating  
6 surfaces of said mold to stabilize said skeleton member;

7 injecting soft synthetic resin into said mold; and

8 removing portions of said fixing shafts projected from the surface of the doll after  
9 molding and treating marks left on the surface of the doll due to removal of the projected  
10 portions of said fixing shafts, the soft synthetic resin and rigid synthetic resin are welded together  
11 within the mold.

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1 57. (Amended) A method for manufacturing an elastic doll as defined in claim 18  
2 wherein the elastic doll includes a trunk, arms and legs in which said skeleton member is  
3 embedded;

4 said step of insert molding said second cores includes forming fixing shafts which  
5 extend from said second cores to a surface of the doll; and

6 said step of insert molding said skin/flesh member includes arranging said  
7 skeleton member in a mold for molding the skin/flesh member, fixing said fixing shafts on  
8 mating surfaces of said mold to stabilize said skeleton member and injecting the soft synthetic  
9 resin into said mold,

10 further comprising the steps of removing portions of said fixing shafts projected from the  
11 surface of the doll after molding and treating marks left on the surface of the doll due to removal  
12 of the projected portions of said fixing shafts by a hot air procedure to melt the surface adjacent  
13 the marks and the flexible first cores are formed of one of a stainless steel and iron fixedly  
14 attached to the second cores.

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Please add the following newly drafted Claims 58-65:

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1 58. (New) A method of forming a doll with simulated natural bending appendages to  
2 simulate a living creature, comprising:  
3 forming a metal frame;

4 covering the metal frame with a first synthetic resin material having a hardness  
5 value within a range of 25 to 35 to limit bending of the metal frame;

6 molding a plurality of rigid core sections at positions spaced along the metal  
7 frame while exposing the covered metal frame in positions corresponding to anatomical joints of  
8 the living creature; and

9 molding a second soft synthetic resin to surround the metal frame and the  
10 plurality of rigid core sections to simulate the tissue of the living creature.

1 59. (New) The method of forming a doll as defined in Claim 58 wherein the metal  
2 frame includes a plurality of wire members bent to provide a pair of substantially parallel  
3 portions extending from a bent intermediate section.

1 60. (New) The method of forming a doll as defined in Claim 59 wherein the first  
2 synthetic resin and the second synthetic resin are formed of compatible thermoplastic elastomers  
3 to weld together when contacting each other in a mold.

1 61. (New) The method of forming a doll as defined in Claim 60 wherein the metal  
2 frame is principally formed of iron.

1 62. (New) The method of forming a doll as defined in Claim 61 wherein the metal  
2 frame is held magnetically during the molding steps.

1 63. (New) The method of forming a doll as defined in Claim 60 wherein the rigid  
2 core sections are molded of a polyolefin resin and the second soft synthetic resin is an elastomer.

1 64. (New) The method of forming a doll as defined in Claim 60 wherein the rigid  
2 core sections are molded of a polypropylene and the second soft synthetic resin is a styrene  
3 elastomer with a hardness value within a range of 10 to 20.

B7  
1 65. (New) The method of forming a doll as defined in Class 64 wherein the first  
2 synthetic resin material is a styrene elastomer.

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